

Date: Thursday, 5/11/2006 10:41:57 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT	
Job Number	: 27072		Part Number	: D2565207	
Estimate Number	: 10959		Drawing Number	: D2565 REV E	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/11/2006	S.O. No. : N/A	Drawing Revision	: E	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/18/2006	
Previous Run	: 26235		Qty:	4	Um: Each
Written By	<u>SEE N/A COMMENT Below</u>				
Checked & Approved By	<u>DA 06.05.11</u>				
Comment	: Est: D 01.08.28 Added Powder coat, and added Inspection level 3 and 21. SM				
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	M304TR0750W049	304 RD Tube .750 x .049W 			
Comment: Qty.: 1.8812 f(s)/Unit Total : 7.5247 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: <u>H100797</u> FF 06.05.15					
2.0	BRAKE NC	NC BRAKE 			
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313 FF 06.05.15					
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 			
Comment: SMALL & MEDIUM FAB RESOURCE 1					
Deburr and polish m.r. 06.05.16					
4.0	QC5	INSPECT WORK TO CURRENT STEP 			
Comment: INSPECT WORK TO CURRENT STEP SB 06/05/16					
5.0	POWDER COATING	POWDER COATING 			
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 DC 06/05/16 (4)					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 

Date: 06/05/18

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 5/11/2006 10:41:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 27072

Part Number: D2565207

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		DC a.m 06-05-16 4
Comment: INSPECT POWDER COAT		
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		AF 06/05/17 ④
Comment: PACKAGING RESOURCE #1		
Identify and Stock		
Location: ST186		
8.0	DC	DOCUMENT CONTROL
		SP 06/05/18 ③
Comment: DOCUMENT CONTROL		
Inspection Level 21		

Job Completion



W 06/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

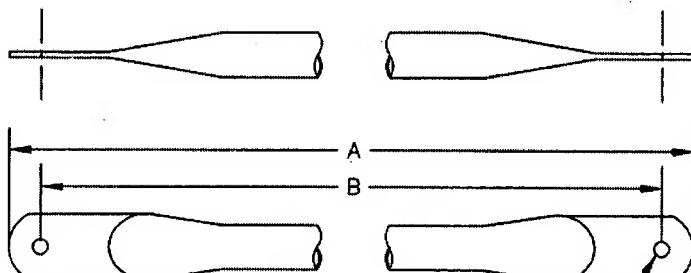
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3

RELEASED
 04.05.05

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D


 DIA 0.257 TO BE PUNCHED
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
 (REF DART SPEC. M304TR0.750W0.049)
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 WITHOUT NOTICE
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

NO. 27072

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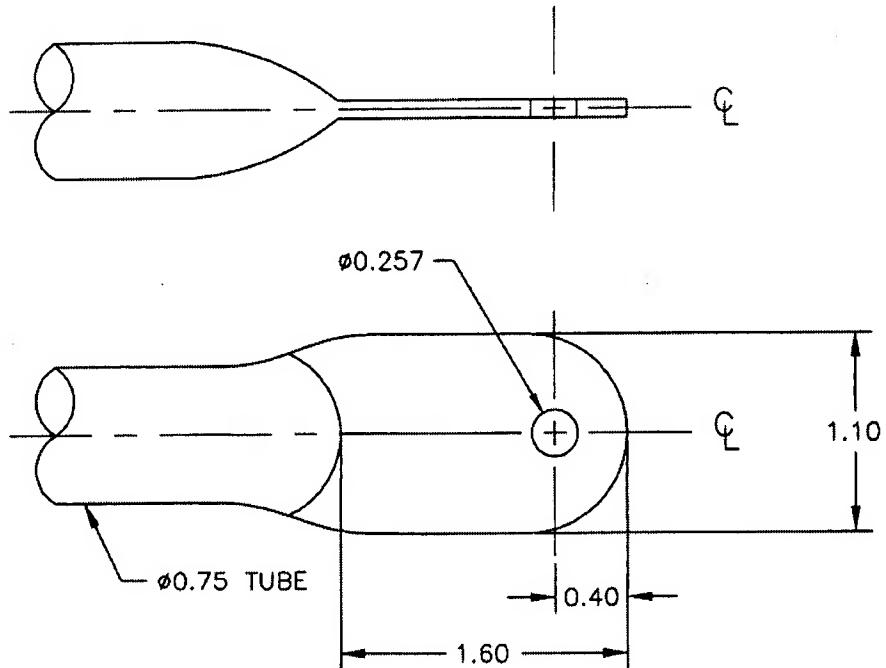
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DNY	APPROVED J	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
4/6/07/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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